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UNITHERM Food Systems, Inc.

Cooking Trial Data

		Product:		Cook Time		Temperatures C.		Start Weight	Cooked Weight	Yield	Internal Temp. F.	Remark
Test #	Belt Speed	Zone 1	Zone 2									
#1	71 Hz	570° F	650° F							39°	30% CHARSOUL SELECT 24P COULD BE TWO DARK FOR THEM	
#2	90 Hz	570°	650°							38°	30% CHARSOUL SELECT 24P	
#3	90 Hz	570°	650°							38°	FRESH MIX 30% 24P	
#4	103	570	650							39°	30% 24P (10 SECOND 1.0)	
#5	120	570	650							38°	30% 24P (10 SECOND 1.0)	
#6	70	570	650							38°	NO SMOKE - OVEN ROASTED	

NOTES

#1

#2

#3

#4

#5

#6

UNITHERM Food Systems, Inc.**Cooking Trial Data**

Date:

Test #	Belt Speed	Cook Time	Product:	Supplied By:					
				Temperatures C.		Start Weight	Cooked Weight	Yield	Internal Temp. F.
				Zone 1	Zone 2				Remarks
#1		7 min 550	220						307° 24°
#2									
#3									
#4									
#5									
#6									

NOTES

#1

#2

#3

#4

#5

#6

U-8200

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PTO-004097

UNITHERM Food Systems, Inc.

Cooking Trial Data

Product: TURKEY
Supplied By: Pennville Farms

Test #	Belt Speed	Cook Time	Temperatures C.	Start Weight	Cooked Weight	Yield	Internal Temp. F.	Remarks
			Zone 1	Zone 2				
#1	71	6.5 MINUTES	570°	650°F				30% CHARSOLO SELECT 24P
#2	90	5.5 MINUTES	570°	650°				30% CHARSOLO SELECT 24P
#3	90	5.5 MINUTES	570°	650°				30% CHARSOLO SELECT 24P
#4	103	4.5 MINUTES	570°	650°				30% CHARSOLO SELECT 24P
#5	120	4 MINUTES	570°	650°				30% CHARSOLO SELECT 24P - 10 SECOND DIP - (15. 30 sec)
#6	70	6.6 MIN	570°	650°				NO SMOKE - OVEN ROASTED
NOTES								
#1								
#2								
#3								
#4								
#5								
#6								

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U-8104

PTO-004098

UNITHERM Food Systems, Inc.

Cooking Trial Data

Date: 2 / 6 / 97

Supplied By: TCAH VILLE FARMS

UNITHERM Food Systems, Inc.						
Cooking Trial Data			Product: TURKEY			
Test #	Belt Speed	Cook Time	Temperatures C.	Start Weight	Cooked Weight	Yield
#7	70	6.6 MINUTES	570°	650°		
#8	120	4 MINUTES	570°	650°		
#9	120	4 MINUTES	570°	650°		

Supplied By: TANVILLE FARMS

Date: 2/6/81

50% Mix of Sprayed Sugar

20% Chassoc Select 24P

20% Charbon Select 24P

NOTES

#1 #2 #3 #4 #5

U-8105

PTO-004099

January 27, 1997

Tim McConnell
FOSTER FARMS
520 "C" St.
Turlock, CA 95380

Via Fax # 209-394-6463

Dear Tim:

It is important to read all of the notes when looking at the product. You will notice subtle changes in the process.

SMOKED PRODUCTS

Product No. 1

This was dipped in liquid smoke for 60 sec.
Solution was Charcoal Select, 70 Smoke / 30 Water
Oven Temp.: 265° C.
Dwell Time: 10 minutes
Cook Yield: 98½ percent

No. 2

This was dipped in liquid smoke for 60 sec.
Solution was Charcoal Select, 50 Smoke / 50 Water
Oven Temp.: 265° C.
Dwell Time: 10 minutes
Cook Yield: 98 percent

No. 3

The same as No. 2

U-00645

PTO-004064

No. 5

This was dipped in 30 percent Smoke / 70 percent Water
Oven Temp.: 265° C.
Dwell Time: 10 minutes
Cook Yield: 98½ percent

No. 10

This product was dipped for 30 seconds in a 30 percent Smoke concentration.
Oven Temp.: 280° C.
Dwell Time: 10 minutes
Cook Yield: 98½ percent

Fans were reversed to drive heat through the belt.

ROASTED PRODUCTSNo. 11

The dwell time for this product was increased to 20 minutes and the fans reversed to drive the energy through the belt. Yield was 93 percent.

The variables are time, temperature, and smoke concentration. The direction of the fans can deliver energy locally across the crown and through the belt. By reversing the fans on a one-zone oven, you direct more energy to the inside of the product.

I noticed that the peripheral edge of the product charred. This may be desirable or you may seek to eliminate it. This can be achieved by introducing super-heated vapor from steam. On this trial we did not use this process; however, during Gary's site visit, I will demonstrate this.

Please ring if you have any questions.

Regards,

David Howard
President

DH&S™

U-00346

PTO-004065

UNITHERM Food Systems, Inc.

Date: January 27, 1997

Cooking Trial Data

Product: Turkey

• NOTE: Crowns did not have any dextrose or sugar ingredients in the deli rolls.

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U-8214

PTO-004066

UNITHERM Food Systems, Inc.							Date:	
Cooking Trial Data								
Test #	Belt Speed	Cook Time	Product:		Supplied By:		Remark	
			Zone 1	Zone 2	Start Weight	Cooked Weight	Yield	Internal Temp. F.
#1					8.38	8.00	4.53	Smoked + Cured
#2					7.97	7.61		Bacon only skinless
#3					8.385	7.88	4.0	SKIN ON
#4					7.70	7.54	5.574 and	skinless
#5					8.15	7.33		"
#6					9.62	22.52		
NOTES							SMOKE 50/50 Charcoal Supreme	
#1	1st trial 10 min						STOKE 50/50	
#2	In effect of - In effect after to get char burn							
#3								
#4								
#5								
#6								

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U-8215

PTO-004067

UNITHERM Food Systems, Inc.

Cooking Trial Data

Date:

Test #	Belt Speed	Cook Time	Product:	Supplied By:		
				Zone 1	Zone 2	Internal Temp. F.
#1	15 min.	300°	350°	300°	7.190	5.4°
#2	300	300	300	7.92	7.425	6.3°
#3				7.630	7.310	4.2°
#4				7.075	4.76	4.3
#5				8.91	8.55	4.04
#6				7.395	6.970	
NOTES				9.71	9.180	Skewer
#1						
#2						
#3						Crowns
#4						X note - reheated did not have any deloose or souple pink pink in the deli rolls
#5						
#6						

PTO-004068

U-8216

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1/30/97

Total Unit length 37'

Heating length 27'

$$27' \times 12'' = 324'' = 32.4$$

Say 10 Min cycle

304

~~3753~~ $1953^{\#} \times 6 = 11,718^{\#}/\text{hr}$ present trench

~~4 ps~~ $1593 \times 6 = 9558^{\#}/\text{hr} \times 16 = 153,928^{\#}$
~~17.7 psf~~ ~~1062 psf/hr~~

5 Days $764,640/\text{L}$

or 6 Days $917,568/\text{nd}$

~~10"~~ Center $27' \text{ in blnthen} \times 12'' = 324''$

~~Concrete~~ End over will kill @ 9[#] psf $36^{\#} \times 32.4 = 1166^{\#}$

$4 \text{ psf} \times 32.4 = 129.6 \times 6 = 777.6 \text{ psf}$

$1166 \times 6 (\text{in}) = 6996^{\#}/\text{hr} = \text{or } 13^{\#}/\text{min}$

$119,936^{\#}/10 \text{ hr day}$

$559,680^{\#}/5 \text{ Days week}$

or $671,616^{\#}/6 \text{ Days week}$

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(D) 3 Fox - N. Smoke
Bell Speed Setting 49.25

39" Belt
7½" Smoker

1/25/57

Time 9.92

Center
9.88

ft.
9.92

14 Min. 9.49

9.47

9.52

Internal Temp Int. 35°

2

1/4 Surface 156°

151°

152°

External

35°

35°

35°

Burnt Lots - Top Bubble - Burned Ckr

Anderson - Little color development
- Burnt over the bar

Conclusion

- Slow speed down to 10 min

1/28/17

Test 2

Belt Speed

72

30 Sec. Smoked Pyral

9.94 #

N.D.
9.88 #

Surface

43 "

Bottom

37 "

Hot of Oven

9.64 # (3,027.)

9.62 #

(2,657.)

9 Min 45 in oven

1/4" Surface

116 °

109 °

Bottom

38 °

39 °

Observation:

Smoked : Good Reddish Tone.

Minor blistering on Top

Smoke Steaming

Plane : Minor blistering on Tip

Conclusion : Reduce time to 9 min

WB-000055

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PTO-004071

Test 3

1/28/97

Setting 80

10 DC (11)

1ft

RT
Center

Plain
Center

9.92

9.93

9.91

Time 9 Min

9.64 (2.8%)

9.68 (2.52%)

9.66 (2.

Surface
Int

125

115

40°

39

1ft: Smoke: No smoke streaking
Slightly light smoke color
Good uniformity
Very minor blistering

Target: Make smoke slightly more conc.
Reduce Zone 3 Temp by 50°F

RT Smoke: Smoke streaking

PTO-004072

Plain: Very minor blistering

WB-000056

CONFIDENTIAL

Test #4

11/28/97

	<u>LFT</u>	<u>KT</u>
Setting 80	10 DC 1/1 - Last	10 DC 1/1 Zone reduced by
	9.92	9.89
Control Wt	9.67 (2.57)	9.65 (2.43) (2.43 ?)
Surface	104°	121°
Internal	38°	39°

Evaluation: 10 DC 1/1 → Eliminates the blistering
Gas bubbles
Slightly light smoke color
No streaking

10 DC 2/1 → Minor burnt spots
Uniform color
Some streaking

PTO-004073

WB-000057

CONFIDENTIAL

Test 5
304
14t
100 (2/1)

Setting 86

204
Rt

1/28/97

8.87

9.61 - Heat Run

9.56 - Nickel

8 Min 41 sec

Out of oven ~~8.68~~ (2.22%) 9.30 (2.72%)

Surface	140	116°
Lat	34°	34°

Evaluation of 304 : More reddish tone
Uniformity
Darker than expected or pros.

Evaluation of 204 : Not Mr. Forno color
Pretty golden brown color

PTO-004074

WB-000058

CONFIDENTIAL

Test 6

304

1/28/27

Surface
Internal

39°

33°

8.85

Setting 102

Oven Dwell Time 6 Min 47 sec

Cooked Wt

8.67 # (2.03?)

Comments

{ Lighter cooler
Was sweating out of oven
Removed ME Jr

Test 7

304

Wt

8.88 #

Setting 90

Oven Dwell Time

7 Min 48 sec

8.70 # (1.91?)

Comments

{ ~~Excellent~~ Very Good C.

CONFIDENTIAL

WB-000059

PTO-004075

Teet #8 #304

11/28/97

Setting 90 Drill Time 2 min 5
Drench System

	Time Setting	90
Top	1st Zone	600
Bottom	2nd Zone	650
Top	3rd Zone	550

Smoke 100 (2/1)
Drench 34 sec (2 zones)

			<u>Wt time</u>	<u>% Loss</u>
1)	8.90	8.74	.16	1.80%
2)	8.87	8.71	.16	1.82%
3)	8.90	8.75	.15	1.68%
4)	8.85	8.71	.14	1.58%
5)	8.87	8.72	.15	1.69%
6)	8.91	8.76	.15	1.68%
7)	8.89	8.75	.14	1.63%
8)	8.88	8.75	.13	1.46%
9)	8.84	8.72	.12	1.36%
10)	8.77	8.74	.11	
11)	8.93	8.77	.16	1.79
12)	8.90	8.75	.15	(1.68%)
13)	8.85	8.69	.16	1.81
14)	8.94	8.79	.15	1.67
15)	8.90	8.76	.14	1.57

Conclusion - poor color uniformity; sides very light

Avg : 8.70 . 7.10 . 1.00 . 0.00

WB-000060

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Protocol - 1 sec @ 50 sec drench with Last 2 200
7 Min 50 sec Cool color - Dark Side

PTO-004076

Test #9

± 304

1/28/87

Time setting 90 Drill Time

Bottom	1 \pm 2 sec	650
Bottom	2 \pm 2 sec	650
Top	3 \pm 2 sec	550

Stroke	150 (2/1)
Drench	50 sec (3 zones)

1) 8.90

2) 8.90

3) 8.85

4) 8.88

5) 8.84

Production

Volume

$44.37 \# / 10''$

$37' \times 2'' = 444'' = 44.4$

~~5 yr~~ $1953^{\#} \times 7 = 13675^{\#} / \text{hr}$

~~4 yr~~ $1801^{\#} / \text{sol.} = 35.9^{\#} = 1593^{\#} \times 7 \underline{11,157^{\#} / \text{hr}}$
 $\times 16$

$178,523^{\#} / \text{hr}$

$892,617^{\#} / \text{hr}$

WB-000061

PTO-004077

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1/29/87

Observations

- 1) Conveyor too light Needs to hold 16
- Question why it shouldn't be same as the
belt on the test unit?
Dave talked about that
- 2) convert color variability & yield variability
- 1) Fan distance setting - OK, but angle can be changed
- 2) Baffle blocking } to give better air on side

Over + n	2x	572 °F	300 °C
Under	2x	670 °F	350 °C

PTO-004078

WB-000062

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~~Tut ism~~
10

44 - Hickory Shaker Code 52934

11/28/87

Time Setting	90	Dwell Time	7 Min 42 sec
Bottom	1 at 2 sec	640	Smoke 100 (21)
Bottom	2 at 2 sec	650	Smell Dwell 70 sec (4 sec)
Top	3 at 2 sec	550	10" on center

1	9.86	9.686	1.717.
2	9.92	9.78	1.417.
3	9.87	9.81	1.417.
4	9.95	9.734	<u>1.387.</u>

4 pos run in front

After 4 pos run

4 pos run after

PTO-004079

WB-000063

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Test 11 44 - Hickory Code 57934

1/29/92

Time setting 80
Bottom Air 1st zone 650
Bottom Air 2nd zone 670
Top Air 3rd zone 550

Drill Time 8 Min 40s
Smoke 100 (2/1)
Smoke Drill 70 sec (42 sec)

1)	9.88	9.646
2)	9.89	9.70
3)	9.20	9.716
4)	9.91	9.736

2.37?
1.92?
1.86?
1.75?

Gard on one side
Better with f. 1.3.
Lightest

PTO-004080

WB-000064

CONFIDENTIAL

1/29/97

Test # 12 . 44 Hickory Code 57934

Time Setting	76 ↓	Dwell Time	9 min
Bottom 1 st Zone	650	Smoke 100 (2/1)	
Bottom 2 nd Zone	670	Smoke Dwell 70sec (42cm)	
Top 3 rd Zone	570 ↑		

1)	9.93	9.676	2.56%
2)	9.93	9.720	2.11%
3)	9.91	9.708	2.04%
4)	9.90	9.71	1.92%

4 Per side
4 Per Test
4 Per side
Adjust Buffer

To Light

PTO-004081

WB-000065

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TEST 13

44 Hickory 57934

1/29/9

Objective: Use Zone 2 + 3 to look at ratio of Top + Bot
Time Setting 46 : Drill time 9 Min 40.
Bottom Zone 2 - 670 Smoke 100 (21)
Top Zone 3 - 570 Smoke Drill 70 Sec (42..

1)	9.90	9.60	3.03%
2)	9.92	9.64	2.78%
3)	9.91	9.628	2.84%
4)	9.89	9.628	2.65%

All dark color - Maybe +, Dark
Fluid better

PTO-004082

WB-000066

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Test 14

44 Hickory

S-2934

1/29/97

Time setting 76

~~1000~~

Top Zone 1 570

Bottom Zone 2 670

Top Zone 3 570

Dwell time 9 Min 30

Smoke 100 (2/1)

Smoke Dwell 70 sec (42.)

1	9.90	9.646	2.567.
2	9.89	9.626	2.672.
3	9.76	9.524	2.427.
4	9.91	9.676	2.367.

Product before and after

Evaluation At 4 on color chart
Top darker than sides

PTO-004083

WB-000067

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Test 15

44 Hickory 57934

11/29/97

Time Setting 48

Top Zone 1 570°F
Bottom Zone 2 670°F

Dwell time 9 min 20.
Smoke 100 (2/1)
Smoke Dwell 76 sec (42..)

①	9.91	9.644	2.67?
②	9.94	9.704	2.37?
③	9.86	9.876	2.37?
④	9.91	9.616	2.47?

Product bc

Evaluation : More uniformity of color
Very good color

PTO-004084

WB-000068

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Test 16

44 Hickory 57934

1/29/41

Time Setting 48

Top Zone 1 570°

Bottom Zone 2 670°

Dwell time 9 min 34.

Smoke 100 (2/1)

Smoke Dwell 70 sec (42 sec)

Change in belt position; side ways

Belt Loading 17" to 18" for 2

122	1)	9.88	9.627	2.597
116	2)	9.93	9.712	2.207
	3)	9.86	9.642	2.217
	4)	9.95	9.736	2.157

Evaluation: Major color

PTO-004085

WB-000069

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Test 23

444 - # 5-7934

11/30/97

Product Test Core 40-42'

Time Setting 76

Dwell Time 9 min

Top Zone 1 570

Side 100 (2/1)

Bottom Zone 2 670

Side Dwell 70 sec (4.21--)

Bottom Zone 3 670

1) 9.91 9.654 2.58%

2) 9.98 9.724 2.56%

3) 9.69 9.436 2.62%

4) 10.04 9.808 2.31%

Evaluation - Very uniform color

Front side Pcs is darker Far side light
Stratiform color

PTO-004086

WB-000070

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Test 18

444 - # 5-7934

1/30/97

~~Exposure~~

Time Setting 7.2 Dwell Time 9 Min 3:
Top Zone 1 570 (Temp drop) Stroke 100 (2/1)
Bottom Zone 2 670 Stroke Dwell Time 70 sec /430
Bottom Zone 3 670

1)	9.77	9.418	3.6%
2)	9.95	9.658	2.93%
3)	9.81	9.532	2.83%
4)	9.88	9.622	2.61%

Evaluation Slightly Darker Color

PTO-004087

WB-000071

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TEST 19

50204 - Hickory

1/30/97

Time Setting 72 Drill Time 9 Min 30
Top Zone 1 570 Temp Drop Smoke 100 (2/1)
Bottom Zone 2 670 Smoke Drill 20 sec (42)
Bottom Zone 3 670

1)	9.53	9.266	2.77 ?.	
Rise	2)	9.43	9.172	2.73 ?.
	3)	9.53	9.246	2.98 ?.
	4)	9.55	9.284	2.78 ?.

Evaluation: Color little darker than 44's
right side darker

PTO-004088

WB-000072

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Test 20

302-304 Hickory

1/30/87

Time Setting	72	Dwell Time	9 Min 35 sec
Top	Zone 1	570 Tex Dyes	Smoke 100 (211)
Bottom	Zone 2	670	Smoke Dwell 70 sec (4 zone)
Bottom	Zone 3	670	

1)	8.83	All side of machine	
Top Holes 2)	8.70	8.534	1.90% Liquid Smoke in hole
3)	8.85	8.680	1.92%
Top Holes 4)	8.84	8.682	1.79% Liquid Smoke in hole
Top Holes 5)	8.82	8.656	1.86% Liquid Smoke in hole

Evaluation: More of crowning effect
Overall color good
Product too close.

Product too wide for 5 rows
Some pieces have 8" Footprint

PTO-004089

WB-000073

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Trot 21

302-304 Hickory

1/30/97

Time Setting 72 Dwell Time 9 min 30 sec
Top Zone 1 570 Smoke 100 (21)
Bottom Zone 2 670 Smoke Dwell 20 sec (42 sec)
Bottom Zone 3 670

1) 8.83 8.636 2.19?

2) 8.71 8.538 1.97?

3) 8.71 8.538 1.97?

4) 8.84 8.682 1.79?

5) 8.78 8.552 3.05? ?

6) 8.71 8.520 2.18?

7) 8.83 8.648 2.06?

8) 8.70 8.546 1.77?

9) 8.72 8.554 1.90?

4 Wide gives more uniform side color
Color lighter than 304 Control

PTO-004090

WB-000074

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Tint 2²

44 Breast
No smkt smoke

1/30/17

Time Settin 72 Drill Time 9 Min 30 Sec
Top Zone 1 570 Hand Dip 45 Sec
Bottom Zone 2 670 10 DC Mesquite
Bottom Zone 3 670

1/1

1)	10.03	9.262	2.67?
2)	9.29	9.006	3.05?
3)	9.93	9.678	2.53?
4)	9.97	9.69	2.80?

2/1

5)	9.97	9.666	3.05?
6)	10.00	9.752	2.48?
7)	10.05	9.774	2.74?
8)	10.00	9.734	2.66?

Evaluation: 2/1 Slightly Darker
Overall too Light

PTO-004091

WB-000075

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Test 23

44 Best
Mayak Snake

1/30/97

Time setting 63

Dwell time 10 Min 45

Top Zone 1 570

Bottom Zone 2 670 10 DC 2/1 No sprite Smke

Bottom Zone 3 670 45 Sec Hard Dij

~~8.82~~

1) 9.93 9.57 3.62 ?.

2) 10.60 10.268 3.13 ?.

3) 10.23 9.89 3.32 ?.

4) 9.10 8.82 3.08 ?.

Evaluation: Dark than prior test # 22

Still on light side of color range

WB-000076

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PTO-004092

Tut 25

76 Best

11/30/97

Speed Setting	22	Dwell Time	9 min 27 sec
Top Zone 1	570	Mailose Attune	1/1
Bottom Zone 2	670	45 sec	Start Dip
Bottom Zone 3	670		
Ana Color Loss			
1)	8.44	8.126	3.72%
2)	9.38	9.092	3.07%
3)	9.27	8.992	3.00%
4)	10.34	10.046	2.84%

Evaluation: The target color

More uniform than present system

5) 9.10 8.592 5.58% loss

No treatment - In 3^{1/2} roll then ran twice

Golden brown with black highlights

PTO-004093

WB-000077

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Test 24

44 Breast
Marguerite Sonake

11/30/97

Time Setting 6.3

Dwell Time

10 Min 45s

Top Zone 1 572

Pick Hall

Bottom Zone 2 670

40% more color

Bottom Zone 3 670

1/2 the cost

1 Part Water

45 sec Nail Application

1) 9.67 9.326 3.567.

2) 9.84 9.504 3.417.

3) 9.96 9.622 3.397.

4) 9.86 9.572 2.927.

Evaluation: Color closer to target
Left piece on target color
Bottom too dark

~~Test Redo with partial loaded bolt~~

① 9.95 ~~9.0556~~ 3.187.

② 9.87 ~~9.626~~ 3.267.

③ 9.93 ~~9.614~~ 2.797.

④ 9.89 ~~9.642~~ 2.907.

⑤ 9.96 9.640 2.977.

⑥ 9.51 9.246 2.187.

⑦ 9.96 9.676 2.857.

⑧ 9.92 9.644 2.787.

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WB-000078

PTO-004094

Test 26

519⁴² ~~42~~ But Test

1/30/97

Speed Setting 72

Dwell time 9 Min 27 sec

Top Zone 1 - 570 100 45%

Bottom Zone 2 - 670 Nail oscillation 52

Bottom Zone 3 - 670 Water 50%

Hand Dip 45 sec

N. Wte

Too light in color.

PTO-004095

WB-000079

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